



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4327-1

Job Sheet 172724



Part No: D4327-1

Job Qty: 4 ea

Part Name: Angle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 3/8/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A 11.03.09 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		3/7/18	0.00	0.00	Start Up Waterjet		OK 18/03/18
100	Waterjet	4 pcs		3/7/18	0.00	0.26	Waterjet1		OK 18/03/18
110	QC	4 pcs		3/7/18	0.00	0.00	QC2 Waterjet-3		OK 18/03/18
120	QC	4 pcs		3/7/18	0.00	0.00	QC8-4		38
130	Small Fab	4 pcs		3/7/18	0.04	1.00	Small Fab-6		FFDAS 38
140	QC	4 pcs		3/7/18	0.00	0.00	QC5		38
150	HandFinish	4 pcs		3/8/18	0.00	0.37	HandFinish1		3-88 DAS
160	QC	4 pcs		3/8/18	0.00	0.00	QC7-5		38
170	Packaging	4 pcs		3/8/18	0.00	0.00	Packaging3-2		3-88
180	QC21-SA	4 Ea		3/8/18	0.00	0.00	QC21		DAS 21 MAR 15 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	.9360 sf (.234 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	1	91	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Angle	2.157Inches ± 0.010	2.167 2.147		
2	Angle	19.380Inches ± 0.030	19.410 19.350		
3	Angle	0.040Inches ± 0.010	0.050 0.030		

Plex 2/21/18 2:03 PM dart.logan.david



Container No: S046792

Part: D4327-1

Job No: 172724

Serial No/Batch: S046792

Revision:

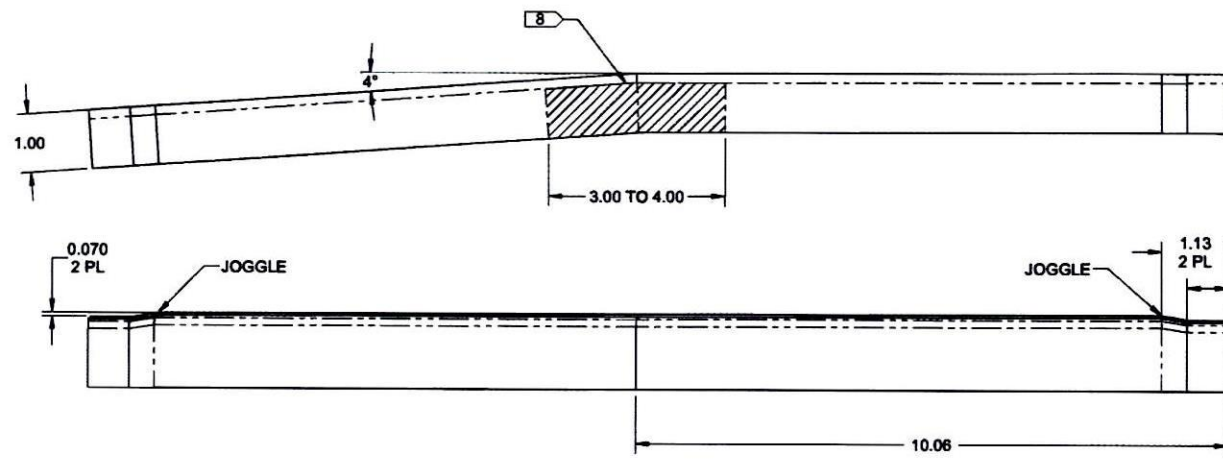
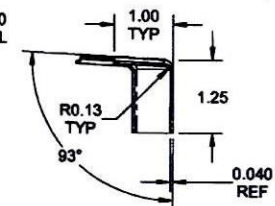
Inspector:

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CANADA
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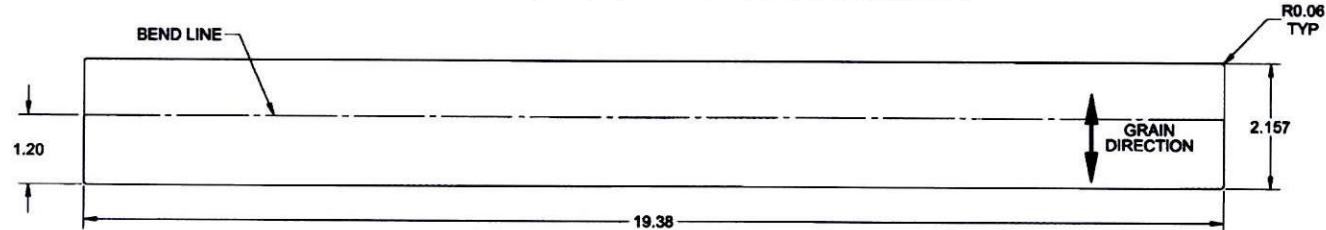
Date: 03/01/18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172724

20180221



D4327-1 ANGLE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-11)



D4327-1F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-11)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs
- 8) SHRINKING AREA TO SUIT DT9753 TEMPLATE

RELEASED
2011-04-06

A NEW ISSUE		RF	10.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.22		
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